

# Work Order ID 69192

Wednesday, May 04, 2011 11:17:07 AM



Page 1

Item ID: D412-705-017

Accept



Setup Start



Revision ID:

Stop



Item Name: N1 Gearbox Access Panel

Start Date: 5/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 11

Date: 11-05-4

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-705-017

CHG001

8606/ko

11-05-4 (2)

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11-05-4 (2)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8606/ko

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69192**

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Page 2

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Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-705-017 Location: \_\_\_\_\_ □ PPP Rev: A

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

\_\_\_\_\_ Purple 20 (2)

\_\_\_\_\_ ck 11/06/10

me  
11-06-10

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**NOTE:** Date & initial all entries

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Page 1



**Abstract**

**Required Qty: 2.00**

**Comments:** IPP Rev:C Removed Manufacturing 06-08-02 JLM  
IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A 		Purchased	No			120	Each	496.0000	30	60			
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST350				496					
				116704				2					
				117161				88					
				117313				406		117313			
D3255-041 		Manufactured	No			120	Each	0.0000	1	2			
Access Panel Assembly													
D3255-042 		Manufactured	No			120	Each	0.0000	1	2			
Access Panel Assembly													
MS20427M3-3 		Purchased	No			120	Each	1,350.000	36	72			
Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST318				1350					
				117206				1350		117206			

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 04, 2011 11:17:15 AM

Page 2

Work Order ID: 69192

Parent Item: D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 5/4/2011

Required Date: 5/9/2011

Start Qty: 2.00

Required Qty: 2.00

MS21060-L3K

Purchased

No

120

Each

216.0000

18

36



Nut Plate

Location

Loc Qty

Loc Code

ST302

216

117291

26

117423

40

117601

150

MS9321-09

Purchased

No

120

Each

839.0000

30

60



Washer

Location

Loc Qty

Loc Code

ST296

839

117087

839

117601

117087

Wednesday, May 04, 2011 11:17:15 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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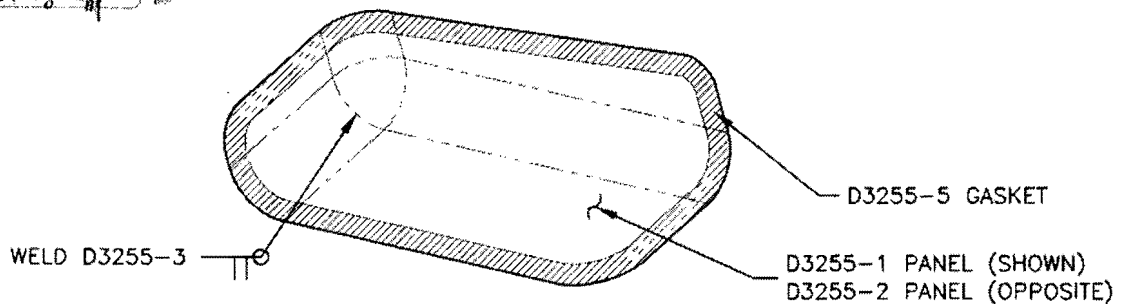
**NOTE:** Date & initial all entries



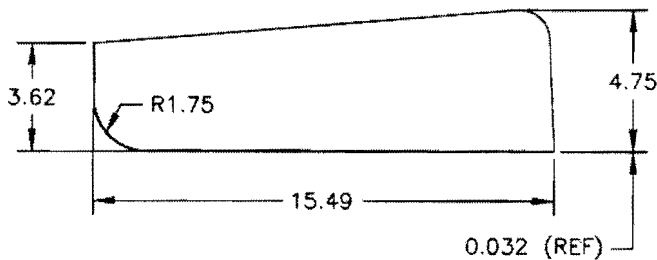
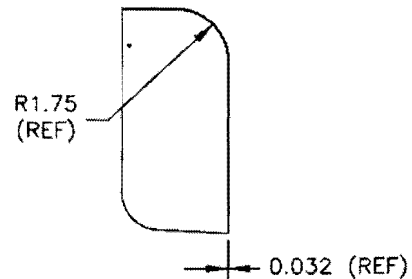
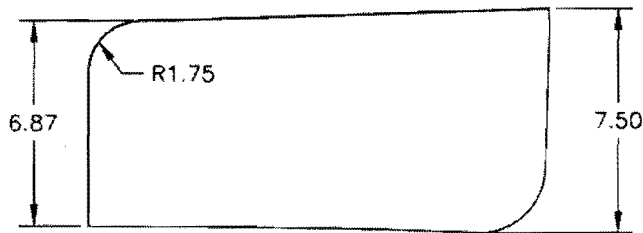


DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ip</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05-01-18 #



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 69192

*11-05-4*

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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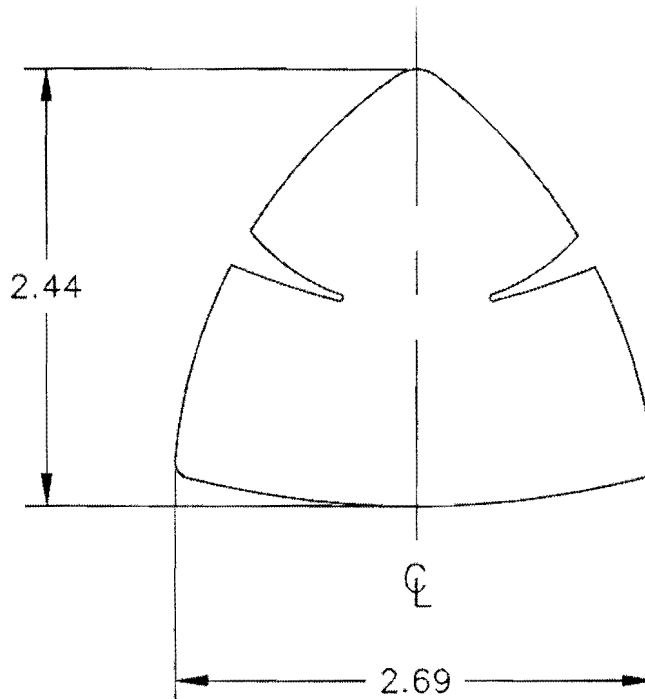
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



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CHECKED 4/	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05.01.08 [Signature]



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

u/b 49192

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

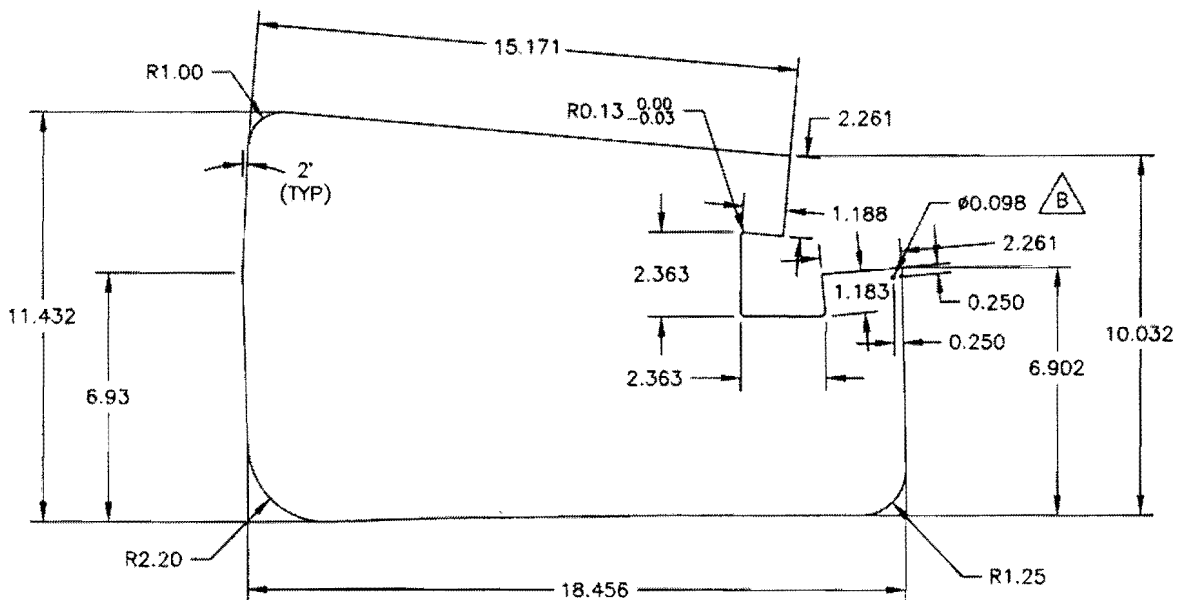
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**NOTE:** Date & initial all entries



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CHECKED JP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18



**D3255-1/-2 FLAT PATTERN**

w/b 49192

**D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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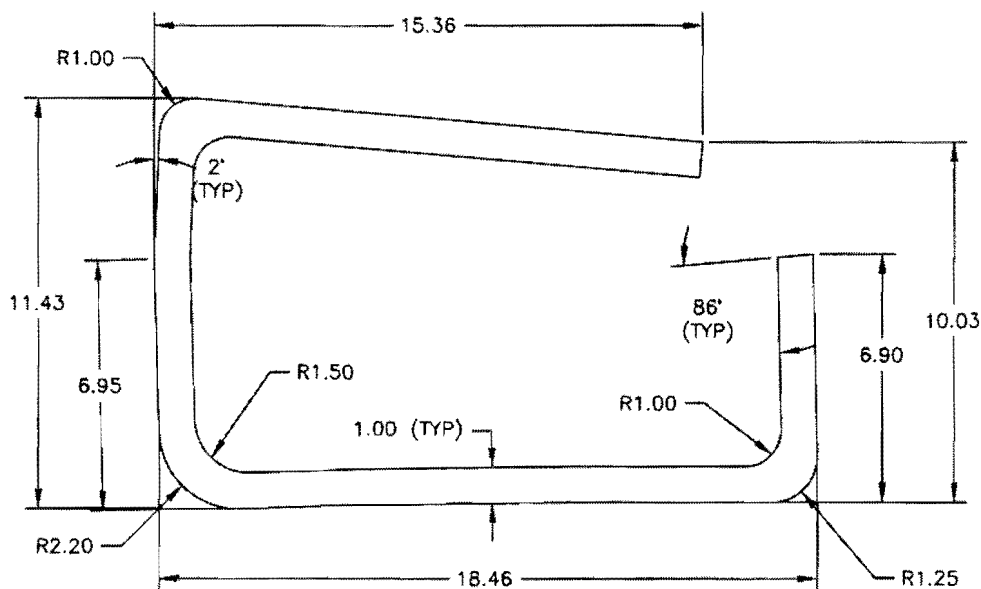
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN IT	DRAWN BY IT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
DS 01.18 #



**D3255-5 GASKET**

w/6 69192

**D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
	16	44	36		12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
	8	22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

